

Work Order ID 150129

Wednesday, August 24, 2016 11:37:21 AM

150129

Page 1

Item ID: 646.9603

Revision ID:

Item Name: Lower Cutter Assy Low

Start Date: 8/31/2016 Start Qty: 2.00

Required Date: 9/6/2016 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

2

Cust Item ID:

2

Customer:

Approvals:

Process Plan:

**DAS
21
9-89**

Date: **AUG 24 2016**

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.9600

N/C

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

**DAS
6
9-89**

SEP 20 2016

120

120

Small Fab

Small Fab

Memo

0.09

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598

exp. date: **07/18**

135439

2x

16/10/17
**DAS
36
9-89**

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.01

2

**DAS
38
9-89**

OCT 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

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Revision ID:

Item Name: Lower Cutter Assy Low

Start Date: 8/31/2016 Start Qty: 2.00

Required Date: 9/6/2016 Req'd Qty: 2.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2******2***

Cust Item ID:

2

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location **CK039**

0.00

140

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER IAW MPP-120

2 **OCT 12 2016** **DAS 6 9-89**

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.03

Quality Control

DAS 21 9-89 **OCT 13 2016**
DAS 21 9-89 **OCT 12 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Wednesday, August 24, 2016 11:37:26 AM

Page 1

Work Order ID: 150129

Parent Item: 646.9603

Parent Item Name: Lower Cutter Assy Low

150129

646 9603

Start Date: 8/31/2016

Required Date: 9/6/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 *646 9701* Cutter Sub Assembly		Manufactured	No			110	Each	4.0000	1	2			
									**	149605		OCT 06 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck012				4					
					145346			4					
646.9813 *646 9813* Lower Deflector Low		Manufactured	No			110	Each	10.0000	1	2			DAS 6 9-89
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK015				10					
					142493			10					
MS21042L08 *MS210421 08* Nut		Purchased	No			110	Each	946.0000	3	6			DAS 6 9-89
									**	135530			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK003				125					
					m135408			125					
				GA				131					
					m134063			131					
				ST303				690					
					m133922			37					
					m135046			153					
					m135133			100					
					m135274			100					
					m135466			300					

SEP 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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Page 2

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Parent Item: 646.9603

Parent Item Name: Lower Cutter Assy Low

150129
646 9603

Start Date: 8/31/2016

Required Date: 9/6/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

411.0000

3

6

MS27039-08-19

Screw

**

135564

DAS
6
8-30

Location

Loc Qty

Loc Code

GA

232

m132930

84

m133077

22

m134063

64

m135046

62

ST277

179

m135408

79

m135466

100

NAS1149FN832P

Purchased

No

110

Each

1,884.000

6

12

NAS1149FN832P

Washer

**

135603

DAS
6
8-30

Location

Loc Qty

Loc Code

GA

1705

M133316

16

M133769

89

M135058

1600

ST263

179

M134257

179

DAS
6
8-30
SEP 27 2016

Wednesday, August 24, 2016 11:37:26 AM

Shop Packet Print

Page 2

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Composite ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐	
--	--	---	--	--	--

Date : _____		Step # : _____		QTY Effective : _____		MRB (QS1042) Approval ☐	
--------------	--	----------------	--	-----------------------	--	--	--

Description Work Order Deviation				Disposition			
Completed By _____				Lead hand / Supervisor Approval Verification _____			
QC / QA Coordinator Approval _____							

Root Cause										FAULT CATEGORY													
☐	Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified
☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	OTHER :
☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	
☐		☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center
☐		☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence

APICAL INDUSTRIES, INC.		ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1		
		DWG NO. 646.9600		REV: N/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG ☐ INC. ☒ UNINC.	
		DWG TITLE: CUTTER ASSY						
		APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER			
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED SCREW LENGTH.						
SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. <u>150129 MJS</u> 160824								
3	R	601.3157	3	3	3	SCREW		MS27039-0818
			.9603	.9602	.9601			
F/N	TC	PART NUMBER	QTY		DESCRIPTION			MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:					☐ MDL ☐ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM		CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

REVISION			
REV	DESCRIPTION	DATE	APPROVE
	LAST PROTOTYPE RELEASE PRI		INC
11/C	FINAL RELEASE	04/30/07	P. B. PAYO



1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, 7, & 8 UPON ASSEMBLY

1				8	646.9813	LOWER DEFLECTOR LOW			
	1			7	646.9812	LOWER DEFLECTOR HIGH			
		1		6	646.9811	UPPER CUTTER DEFLECTOR			
A/R	A/R	A/R	5	601.2045	RTV, LOCITE 598				
3	3	3	4	601.1541	LOCKNUT			N52104208	
3	3	3	3	601.2765	SCREW			N527039-0819	
6	6	6	2	601.2764	WASHER			N431149F0839	
1	1	1	1	646.9701	CUTTER SUB ASSY				
X				646.9603	LOWER CUTTER ASSY LOW				
	X			646.9602	LOWER CUTTER ASSY HIGH				
		X		646.9601	UPPER CUTTER ASSY				
.9603	.9602	.9601	FIN #	PART #	DESCRIPTION			MAT'L	SPEC
QTY				PARTS LIST					
NEXT ASSY (S)				ORIGINAL DATE 2008-01-17 05:57:29 BY J. MCINROY CHECKED J. BRANCO APPROVAL  CONTRACT # 16					
646.9500				UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5° SEE CHANGE CODE B 02M26 DWG NO. 646.9600 SCALE NONE 					
				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300 CUTTER ASSY REV N/C					
				1 SHEET 1 OF 1					